

## GEN 606 Welding Wire and Rod

GEN 606 is a nickel-chromium-iron filler metal used to weld nickel base alloys such as 600, 601, 690 and 800. It is also used for welding dissimilar metals and for overlaying on steel.

### CONFORMANCES

AWS A5.14	:	ERNiCr-3
ASME SFA-5.14	:	ERNiCr-3
UNS	:	N06082

### AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Nb (Cb)	%Ti	%Fe	%Mn
0.10 max 0.04	18.0 – 22.0 20.0	67.0 min 72.7	2.0 – 3.0 2.4	0.75 max 0.40	3.0 max 1.3	2.5 – 3.5 3.0
%Si	%P	%S	%Cu	%Co	Total Others	
0.50 max 0.10	0.03 max 0.003	0.015 max 0.002	0.50 max 0.01	0.12 max 0.03	0.50 max	

### TYPICAL WELD METAL MECHANICAL PROPERTIES

Tensile Strength	:	85,000 psi	586 MPa
Yield Strength	:	50,000 psi	345 MPa
Elongation	:	35 %	

### TYPICAL WELDING PARAMETERS\*

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 18	90 – 130	100% Ar
	3/32"	2.4 mm	15 – 20	120 – 170	100% Ar
	1/8"	3.2 mm	15 – 20	150 – 220	100% Ar
MIG (GMAW)	.035"	0.9 mm	26 – 29	150 – 200	75% Ar – 25% He
	.045"	1.1 mm	28 – 32	180 – 220	75% Ar – 25% He
Sub Arc (SAW)	.093"	2.4 mm	28 – 30	275 – 350	
	.125"	3.2 mm	29 – 32	350 – 450	

\*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<b>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</b> BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.
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